

Date: Wednesday, 11/22/2006 1:40:07 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BRACKET |
| Job Number | : 29653 | | |
| Estimate Number | : 12538 | | |
| P.O. Number | : N/A | Part Number | : D35461 |
| This Issue | : 11/22/2006 S.O. No. : N/A | Drawing Number | : D3546 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : SMALL /MED-FAB | Drawing Revision | : A |
| Previous Run | : 29559 | Material | : N/A |
| Written By | : <u> </u> | Due Date | : 11/29/2006 |
| Checked & Approved By | : <u> </u> | Qty: | 16 |
| Comment | : Est Rev:A New Issue 06-09-27 JLM | Um: | Each |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S18GA | 304/316 .050 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.2205 sf(s)/Unit Total : 1.7640 sf(s) 3.5280
 6061-T6 aluminum sheet .050 Sheet 304.050
 Batch: M100997 ML 06 11 23

(16)

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3546
 Dwg Rev: A
 Prog Rev: A

ML 06 11 23

(16)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



ML 06 11 23

(16)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

ML 06/11/23

(16)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Form as per Dwg D3546

SB 06/11/23

(16)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 28 Date: 06/11/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/22/2006 1:40:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29653

Part Number: D35461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/23 (16)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 11 23 (16)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 4/11/24 (16)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 4/11/24 (16)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC 4/11/24 (16)

Job Completion



CZdel11/24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

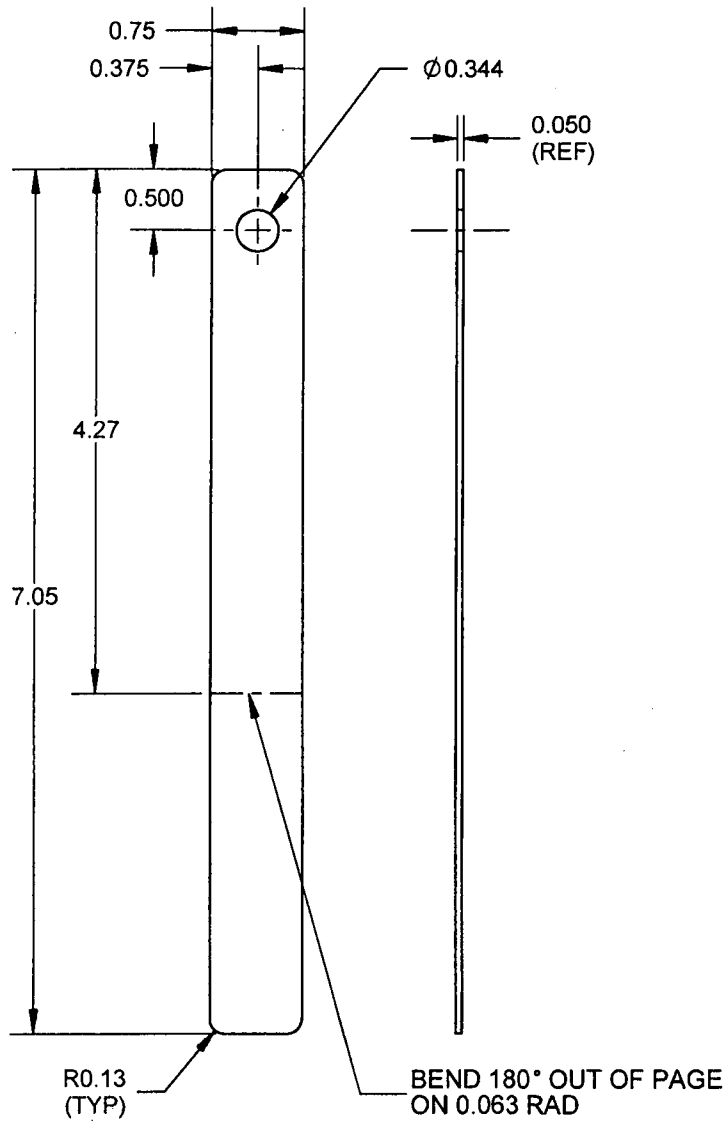
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

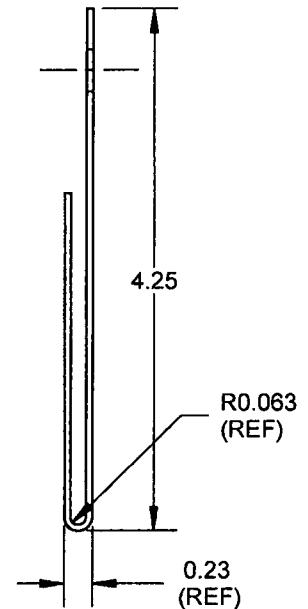
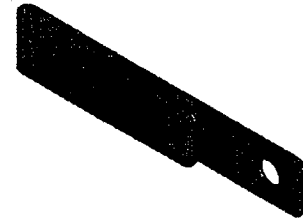
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|-------------------------|--------------------------------------|--|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>LE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>Q</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3546 | REV. A SHEET 1 OF 1 |
| DATE 06.09.15 | TITLE CLIP SCALE 1:1 | | |
| REV A | DATE 06.09.15 | DESCRIPTION NEW ISSUE | |



D3546-1F FLAT PATTERN



D3546-1 CLIP

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **29653**

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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

| | |
|--------------|-----------|
| Measured by: | <i>MM</i> |
| Date: | 06 11 23 |

| | |
|-------------|---|
| Audited by: |  |
| Date: | 06/11/23 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |